

Date: Thursday, 1/11/2007 1:47:53 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COLLECTIVE BELLCRANK
Job Number : 30222	
Estimate Number : 12632	
P.O. Number : N/A	Part Number : D2127251007
This Issue : 1/11/2007 S.O. No. : N/A	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/10/2007 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material : N/A
Written By : <i>JLM 07-01-11</i>	Due Date : 1/17/2007 Qty: 3 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-014-10 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 7075-T7351 2X6.25X7.875
 D6101-003 BILLET
 Batch: *25346*

JLM 07-01-11 (3)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA656 and Dwg D212-725-1

JLM 07-01-11 (3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 07-01-11 (3)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 MILL SLOTS AS PER DWG D212-725-1

JLM 07-01-11 (3)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLM 07-01-11 (3)

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JLM 07-01-11 (3)

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Drawing Name: COLLECTIVE BELLCRANK

Job Number: 30222

Part Number: D2127251007

Job Number:



Seq. #: Machine Or Operation: Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(2)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m/m-b

07/01/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 0701 11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

u 0701.15 3

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



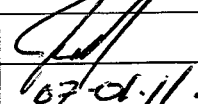
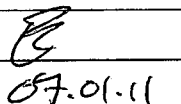
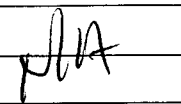
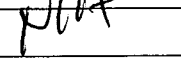
u 07-01.15

DART AEROSPACE LTD		Work Order: 30222
Description: Collective Bellcranks		Part Number: D212-725-1-007
Inspection Dwg: D212-725 (Rev: A)		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

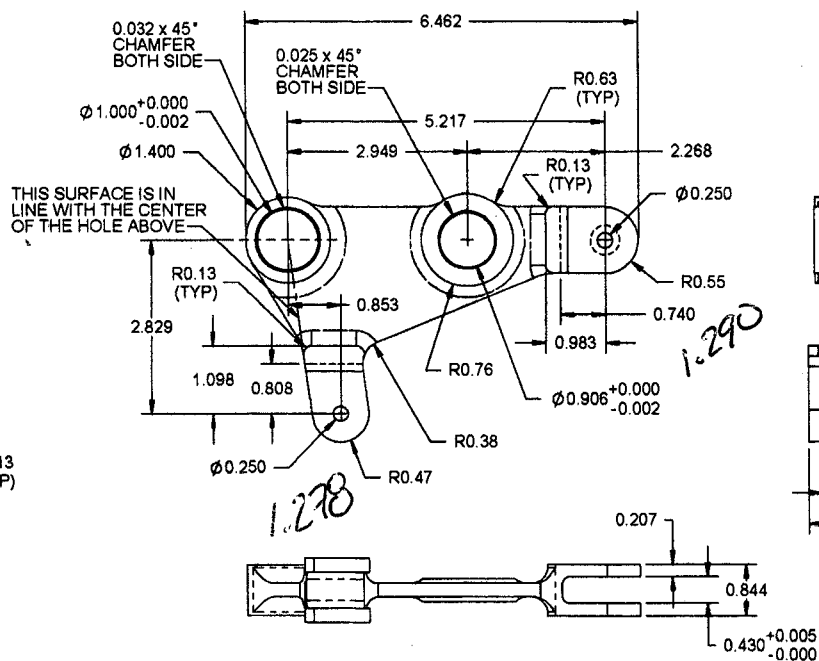
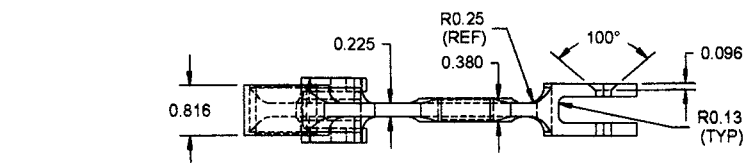
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.816	+/-0.010	.818	✓			
.225	+/-0.010	.226	✓			
.380	+/-0.010	.381	✓			
R.125	+/-0.010	R.125	-			
6.462	+/-0.010	6.460	-			
5.217	+/-0.005	5.217	-			
2.949	+/-0.005	2.948	✓			
Ø1.000	+0.000 -0.002	Ø.998	✓			
Ø.906	+0.000 -0.002	Ø.904				
Ø.250	+0.005 -0.001	Ø.250	✓			
.808	+/-0.010	.812	✓			
.740	+/-0.010	.744	✓			
.983	+/-0.010	.985	✓			
Ø1.400	+/-0.010	Ø1.398	✓			
.844	+/-0.010	.841	✓			
.430	+0.005 -0.000	.432	-			
.207	+/-0.010	.204	-			
1.050	+/-0.010	1.052	✓			
.594	+0.005 -0.000	.594	✓			
.228	+/-0.010	.230	✓			

Measured by: 	Audited by: 	Prototype Approval: 
Date: 07-01-11	Date: 07-01-11	Date: 

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	





D212-725-1-007 COLLECTIVE BELLCRANK

P/N 120-015-5A SLEEVE (1)
SUITED TO FIT BEARING
P/N MS27647-5 BEARING (1)
PRESS FIT

P/N 120-013-3A SLEEVE (1)
SUITED TO FIT BEARING
P/N MS27643-3 BEARING (1)
PRESS FIT

D212-725-1-007
COLLECTIVE BELLCRANK

D212-725-1-901 COLLECTIVE BELLCRANK ASS'Y

NOTES:

- 1) MATERIAL: 7075-T6 OR T651/T6510/T6511/T62 BAR
PER QQ-A-200/11 OR QQ-A-225/9 (REF. DART SPEC. M7075-T6B)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR
PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) LPI PER ASTM 1417 LEVEL 2
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 4 OF 37
DATE 06.12.08		TITLE 212S DETAIL PARTS	SCALE 1:2
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